

Work Order ID 64999

Wednesday, January 05, 2011 1:17:07 PM



Page 1

Item ID: D3656-1

Accept



Setup Start



Revision ID:

Stop



Item Name: PANEL

Start Date: 1/5/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: Date: 11-01-07 Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3656	Rev B								

100

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks to fit frame size

x2

11/01/07

105

0.00



Dry Material

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 240°

Time IN: 3:30 pm 11/01/07

Time OUT: 7:00 am 11/01/07

x2

11/01/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110  Thermoform Thermoforming Machine	THERMOFORMING MACHINE Memo Thermoform as per Dwg. D3656-1 and Folio FTA 015 using tool DT 8986 □ Dwg. Rev. <u>B</u> □ Folio Rev. <u>C</u>	0.00 0.00				x2			<i>Wk</i> 11/01/07
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo Visually inspect for proper formation of each part	0.00 0.00				x2			<i>Dh</i> 11/01/07
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				x2			<i>B</i> 11/01/10

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING Memo Trim to Finished Dimensions as per dwg D3656	0.00 0.00				2			 11/01/10
150 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo Check dimensions to ensure conformity to drawing tolerances.	0.00 0.00				2			 11/01/10
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							

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Required Date: 1/14/2011 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

11/1/13 SL (2)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/13 J

MF
11-01-13

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Picklist Print

Wednesday, January 05, 2011 1:17:11 PM

Page 1

Work Order ID: 64999

Parent Item: D3656-1

Parent Item Name: PANEL



Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev. A 07/12/13 New issue DL verified by:DD
IPP Rev. B 08/09/25 Dwg. Update DL.
Add Sstep 105 Dry Material 10/04/21 DL

IPP Rev. C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MLEXS.093-F6006-07

Purchased

No

100

sf

1,824.630

32

64



GE PLASTICS LEXAN SHEET



Location

Loc Qty

Loc Code

therm

1824.63

107574

6.46

112176

101.2267

114459

1716.9433

64 58 24

11/01/07

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DART AEROSPACE LTD		Work Order:	64999
Description: Panel		Part Number:	D3656-1
Inspection Dwg: D3656 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Free of visual flaws (bumps, cracks, voids, etc.)	✓			

Measured by: B **Date:** 11/01/10

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.070	Min	.074	✓			
0.050	Min	.069	✓			
24.7	REF	24.9	✓			
0.7	REF	0.75	✓			

Measured by: B **Date:** 11/10/10

Audited by: S **Date:** 11/01/13

Prototype Approval: N/A **Date:** N/A

Rev	Date	Change	Revised by	Approved
A	08.05.28	New Issue	KJ/DL	
B	09.09.15	Dimensions updated per Dwg Rev B	KJ	

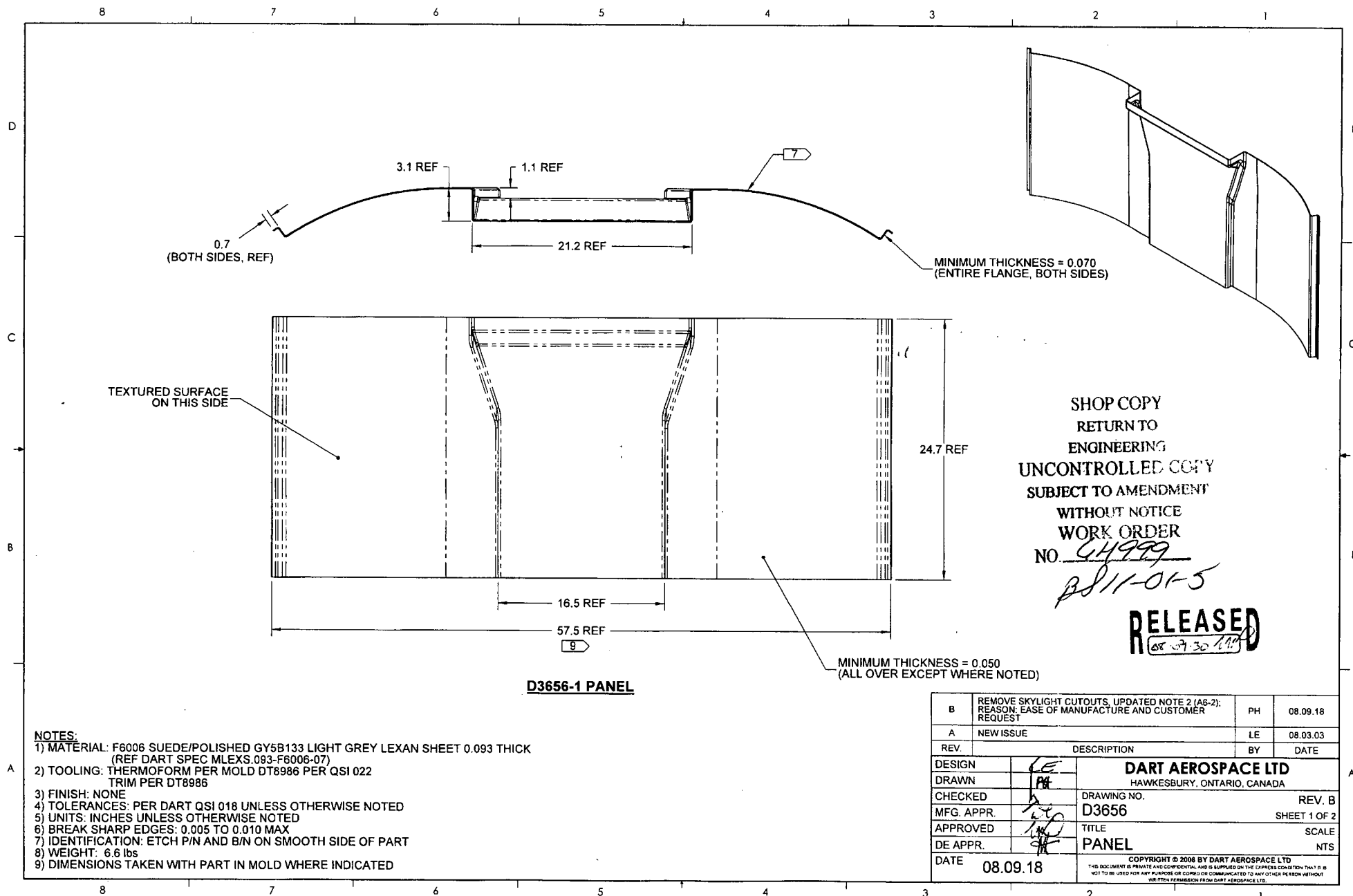
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 4499
BS11-01-5

RELEASED
08-09-18

D3656-1 PANEL

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
- 2) TOOLING: THERMOFORM PER MOLD DT8986 PER QSI 022
TRIM PER DT8986
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 8) WEIGHT: 6.6 lbs
- 9) DIMENSIONS TAKEN WITH PART IN MOLD WHERE INDICATED

B	REMOVE SKYLIGHT CUTOUTS, UPDATED NOTE 2 (A6-2); REASON: EASE OF MANUFACTURE AND CUSTOMER REQUEST	PH	08.09.18
A	NEW ISSUE	LE	08.03.03
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	KE	DRAWING NO.	REV. B
MFG. APPR.	KE	D3656	SHEET 1 OF 2
APPROVED	KE	TITLE	SCALE
DE APPR.	KE	PANEL	NTS
DATE	08.09.18	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

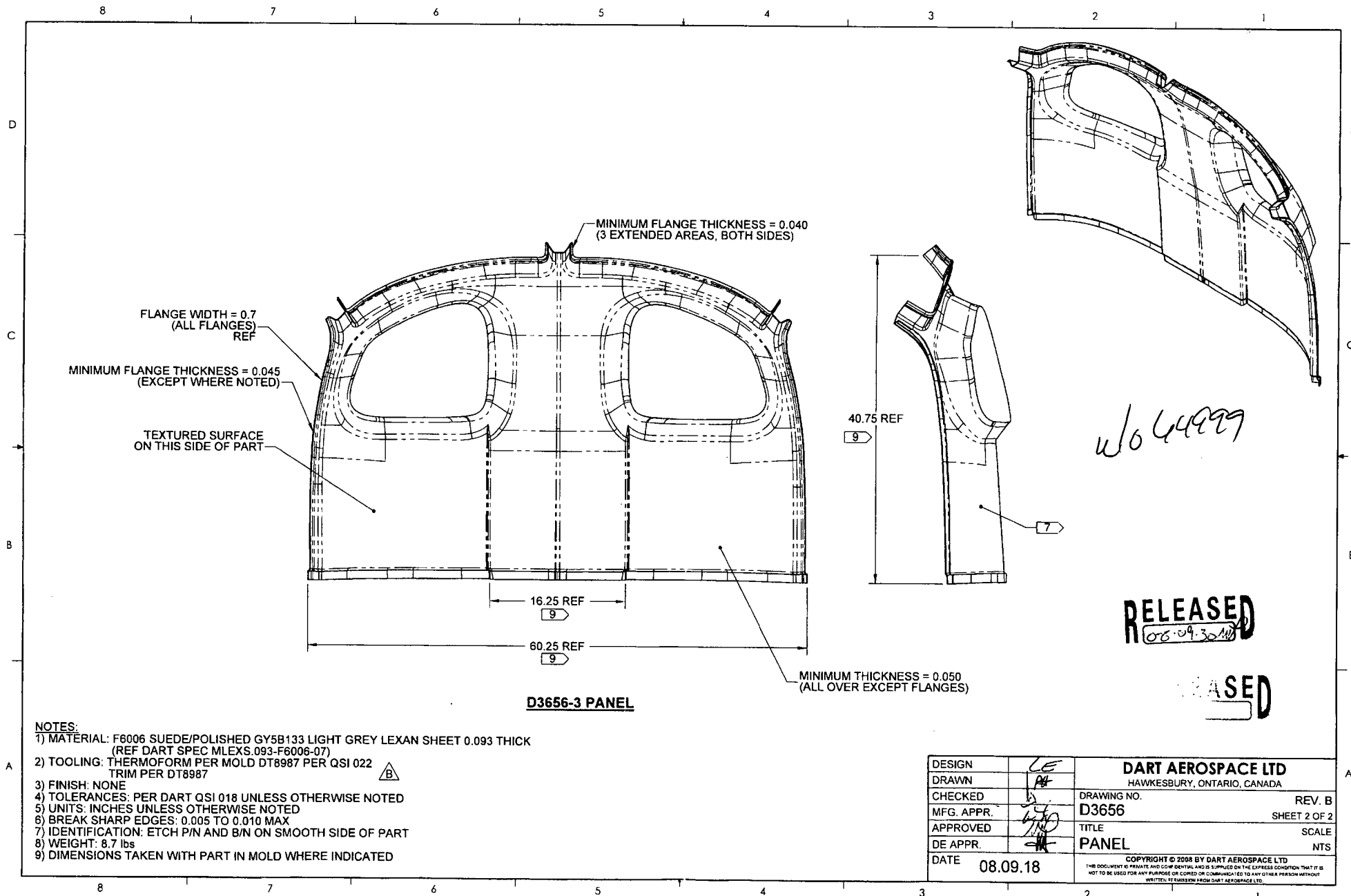
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